

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024344**Date Inspected:** 06-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE TESTING

OBG 14 EAST

ZPMC NWIT No: 09371

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as OBG 14East. The weld designations are as follows:

SEG3019AZ-157, 159, 161, 163, 165, 167, 169, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168, 170

SEG3019F-152, 153, 156, 157, 160, 161, 164, 165, 168, 169, 172, 173, 176, 177, 180, 181, 184, 185, 188, 189, 192, 193, 196, 197, 208

SEG3019H-217, 220, 221, 222, 225, 226, 227, 230, 231, 232, 235, 236, 237, 240, 241, 242, 245, 247, 248, 250,

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251, 252, 255, 257, 258

This QA Inspector randomly observed the following work in progress.

OBG 14 EAST

SHIELDED METAL ARC WELDING PROCESS

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066398 performing the Shielded Metal Arc Welding process on weld 016 located at PCMK SEG3020L. ZPMC QC Mr. Zhu Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066361 performing the Shielded Metal Arc Welding process on weld 127 located at PCMK SEG3020L. ZPMC QC Mr. Zhu Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

WELD REPAIR

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 216086 performing the Shielded Metal Arc Welding process on weld 024 located at PCMK SEG3020AG. ZPMC QC Mr. Zhu Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Weld repair report identified as B-WR21007.

This QA Inspector observed ZPMC qualified welding personnel identified as 501946 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East inside near panel point 127 and panel point 128. VT repair on some locations. ZPMC QC Identified as Zhu Yuan Yuan with Critical welding repair report CWR-B-CWR2944. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F) FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

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Reviewed By: Peterson, Art

QA Reviewer